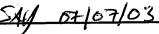
Dart Aerospace Ltd. Tuesday, 26/06/2007 8:57:02 AM Date: User: Linda Lacelle **Process Sheet** : WEARPLATE **Drawing Name** : CU-DAR001 Dart Helicopters Services Customer Job Number : 33115 **Estimate Number** : 10610 : D33197 :NIA **Part Number** P.O. Number : D3319 REV. B S.O. No. : NA **Drawing Number** : 26/06/2007 This Issue Project Number : N/A Prsht Rev. : B · SMALL /MED FAB Type **Drawing Revision** First Issue : 10/07/2007 : 33115 Material Previous Run **Due Date** Qty: 10 Um: Each Written By Checked & Approved By 05.05.12 New issue KJ/JLM Comment Est Rev:B Now on Waterjet 07-06-26 JLM **Additional Product** Job Number: Description: Machine Or Opération: Seq. #: 1010/1025/A21/6aA SHEET .048 1.0 M1010S18GA Comment: Qty.: 0.5754 sf(s)/Unit Total: 5.7540 sf(s) 1010/1025/A21/6aA SHEET .048 Batch: M10442 01 06 WATER JET 2.0 Comment: FLOW WATER JET 1-Cut as per Dwg D3319 MM/ IB 070627 Dwg Rev: B Prog Rev: 13 2-Deburr if necessary INSPECT PARTS AS THEY COME OFF MACHINE 3.0 QC2 PARTS AS THEY COME OFF MACHINE Comment: INSPECT SECOND CHECK 4.0 QC8 Comment: SECOND CHECK 5.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary





Date: Tuesday, 26/06/2007 8:57:02 AM Úser: Linda Lacelle **Process Sheet Drawing Name: WEARPLATE** Customer: CU-DAR001 Dart Helicopters Services Part Number: D33197 Job Number: 33115 Job Number: Description: Seq. #: **Machine Or Operation:** NC BRAKE 6.0 BRAKE NC Comment: NC BRAKE Form using DT8326 & DT8261 as per Dwg D3319 Rev: 7.0 DIMENSIONAL CHECK Comment: DIMENSIONAL CHECK LARGE FABRICATION RESOURCE 1 8.0 - LARGE FAB 1 Comment: LARGE **FABRICATION RESOURCE 1** Weld hard surface using D3319-7T2 per QSI 004 and Dwg D3319 Rev: 5 Batch Part Number Description Qty · <u>M1035</u>51 7560 Hardcoat Rod A/R N/A VISUAL WELDING INSPECTION QC9 9.0 Comment: VISUAL WELDING INSPECTION POWDER COATING POWDER COATING 10.0 **Comment: POWDER COATING** Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3 INSPECT POWDER COAT/CHEMICAL CONVERSION 11.0 QC3 0201 21 Comment: INSPECT POWDER COAT PACKAGING RESOURCE #1. 12.0 **PACKAGING 1 Comment: PACKAGING RESOURCE #1** Identify on inside surface using a permanent fine point marker with the following: TCCA-PDA, Dart Aerospace Ltd. P/N: D3319-7, B/N: BXXXXX For Product Eligibility see PDA05-18 and Stock Location:

Date: Úser: Tuesday, 26/06/2007 8:57:02 AM

Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 33115

Part Number: D33197

Job Number:



Comment: FINAL INSPECTION/W/O RELEASE

Seq. #:

Machine Or Operation:

Description:

13.0

QC21

FINAL INSPECTION/W/O RELEASE

Job Completion



Wording

Date

Monday, 6/25/2007 9:10:11 AM

User:

Kim Johnston

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 33115

Estimate Number

: 10610

P.O. Number

This Issue

: 6/25/2007

Prsht Rev. First Issue Previous Run : NC

: //

S.O. No. :

Type

: PURCHASED PARTS

: 25728

Written By Checked & Approved By

Comment

: Est:

05.05.12

New issue

KJ/JLM

Drawing Name

: WEARPLATE

Part Number

Drawing Number

: D33197 . D3319 REV. B

Project Number

: N/A

: B **Drawing Revision**

Material

Due Date : 7/10/2007 Qty:

Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

2.0

3.0

Comment: PURCHASING

Issue P/O:

Email or Ship\DXF file to vendor Laser Cut flat pattern per Dwg D3319 Possible Supplièr: Industrial Laser

Material release note is required

D33197F

Wearplate

Comment: Qty.:

1.0000 Each(s) Unit

Total:

10.0000 Each(s)

WEARPLATE

PACKAGING '

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Recieive & Inspect for Transit Damage

Ensure Material Release Note is attached

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per inspection template D3319-7T1

5.0

SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary



Page 1

Form: rorocess

Dart Ae	rospace Lt	td							
W/O:			W	ORK ORDER CHANGE	S	***			
DATE	STEP	PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
								٠.	
				· · · · · · · · · · · · · · · · · · ·					
Part No		PAR #:	Fault Cat	egory:	NCR: Yes	No DQ	A:	Date:	
					QA: N	I/C Close	d:	Date: _	
NCR:		,	WORK OR	DER NON-CONFORMAN	ICE (NCF	₹)			
DATE	OTED	Description of NC		Corrective Action Section		Verific	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Secti		Chief Eng	QC Inspector
								·	·
							:		
									-

NOTE: Date & initial all entries

	nday, 6/25/2007 9:10:12 AM		
User: Kim	Johnston	Process Sheet	
Customer:	CU-DAR001 Dart Helicopters Services	Drawing Name: WEARPLATE	
	·		
Job Number:	33115	Part Number: D33197	
Job Number:			
	118111111111111111111111111111111111111		3
Seq. #:	Machine Or Operation:	Description :	
6.0	BRAKE NC	NC BRAKE	1100100001111111111111
Comme			1 1000/19 0 10/10 00/10 100 1
Comme	ent: NC BRAKE Form using DT8326 & D\(\frac{1}{8}261\) as per D	Iwa D3319 Rev	
7.0	QC6	DIMENSIONAL CHECK	
7.0		DIMENSIONAL STREET	
Comme	ent: DIMENSIONAL CHECK		
8.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
. "			
Comme	ent: LARGE FABRICATION RESOURCE 1	·	•
	Weld hard surface using D3319-7T2 per	3	
	Qty Part Number Description	Batch	
	A/R N/A 7560 Hardcoat R		
9.0	QC9	VISUAL WELDING INSPECTION 12	144114 14114 11114 11114 1111
Commo	ent: VISUAL WELDING INSPECTION		1 100 110 1051 5 130 13 60 11 100 6
10.0	POWDER COATING	POWDER COATING	
10.0		, or particular transfer and the second	A 1888 II 818 BI ARRIO 88 II 88 II 88 II
Comme	ent: POWDER COATING		
	Powder Coat Grey Sandtex (Ref: 4.3.5.6	6) as per QSI 005 4.3	
11.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVE	RSION
	{		!
Comme	nt: INSPECT POWDER COAT		
12.0	PACKAGING 1	PACKAGING RESOURCE #1	1 184 (51 1884) 1184 (1881 1881
	! 184(81 11118 1188 1181)		1 (100) (400) (100) (100)
Comme	ent: PACKAGING RESOURCE #1	nant fine naint mades with the fallowing:	
	Identify on inside surface using a perma TCCA-PDA, Dart Aerospace Ltd.	nent line point marker with the lollowing.	
	P/N: D3319-7, B/N: BXXXXX	\	·
	For Product Eligibility see PDA05-18	\	
	and Stock	\	
	Location:		
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Dart Aerospa	ce i	∟td
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W/O:			WORK ORDER	CHANGES			-	· · · · · · · · · · · · · · · · · · ·
DATE	STEP	PR	OCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspector
Part No	:	PAR #:	Fault Category:	NCR: Ye	s No E	QA:	_ Date: _	
				QA	N/C Clo	sed:	_ Date: _	
NCD:			WORK ORDER NON-CON	IFORMANCE (NO	:R)			

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
5.4	STED Description of NC Corrective Action Sect	Corrective Action Section B	n Section B		re Action Section B		Annroval	Ammayal		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector		

NOTE: Date & initial all entries

Date: User:

Monday, 6/25/2007 9:10:12 AM

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 33115

1110

Part Number: D33197

Job Number:

Seq. #:



Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



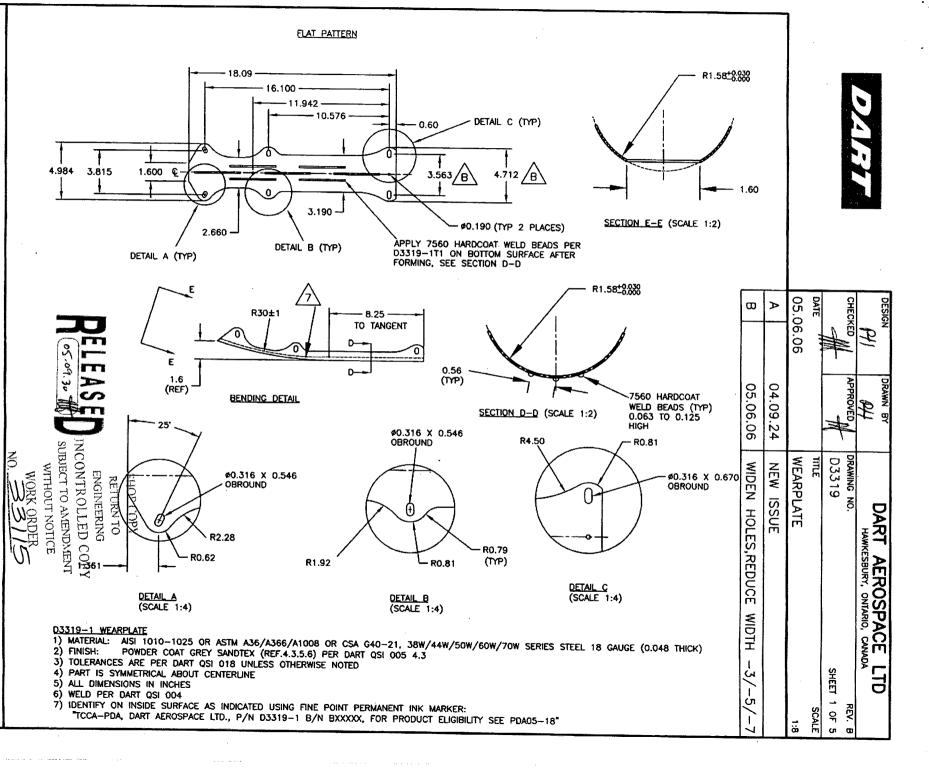
Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #: Pault Category: NO	CR: Yes	s No DQ	A:	Date: _	

QA: N/C Closed: ____ Date: ___

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B	-	Verification	A	Annroyal			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector			

NOTE: Date & initial all entries



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PURPOSE

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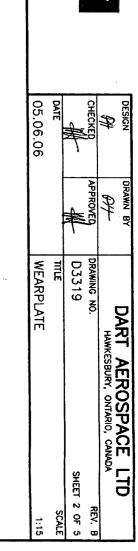
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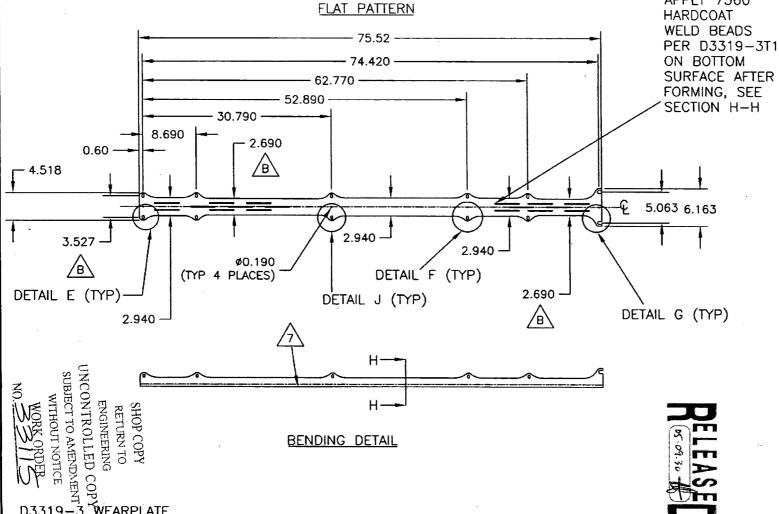
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APPLY 7560





-3 WEARPLATE

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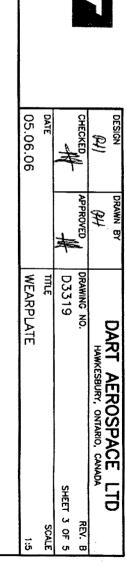
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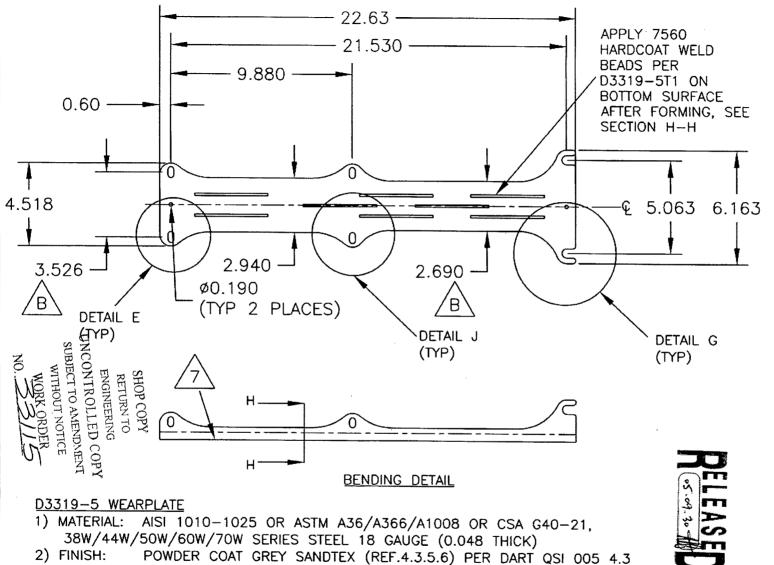
PURPOSE OR

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- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER: "TCCA-PDA, DART AEROSPACE LTD., P/N D3319-3 B/N BXXXXX. FOR PRODUCT ELIGIBILITY SEE PDA05-18"







FLAT PATTERN

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004

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ANY PURPOSE

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IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER: "TCCA-PDA, DART AEROSPACE LTD., P/N D3319-5 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

D3319

SCALE 우 5

WEARPLATE

05.06.06

APPLY 7560 HARDCOAT WELD 12.75 BEADS PER D3319-7T1 ON **BOTTOM SURFACE AFTER** 4.518 11.650 FORMING, SEE SECTION H-H 0.60 3.526 B' 5.063 6.163 2.690 DETAIL E (TYP) DETAIL G (TYP) Ø0.190 (TYP 2 PLACES)

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SUBJECT TO AMENDMENT
WORK ORDER
NOTICE
WORK ORDER
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NOTI

1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)

BENDING DETAIL

POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3 2) FINISH:

FLAT PATTERN

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

PART IS SYMMETRICAL ABOUT CENTERLINE

- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004

7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER: "TCCA-PDA, DART AEROSPACE LTD., P/N D3319-7 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

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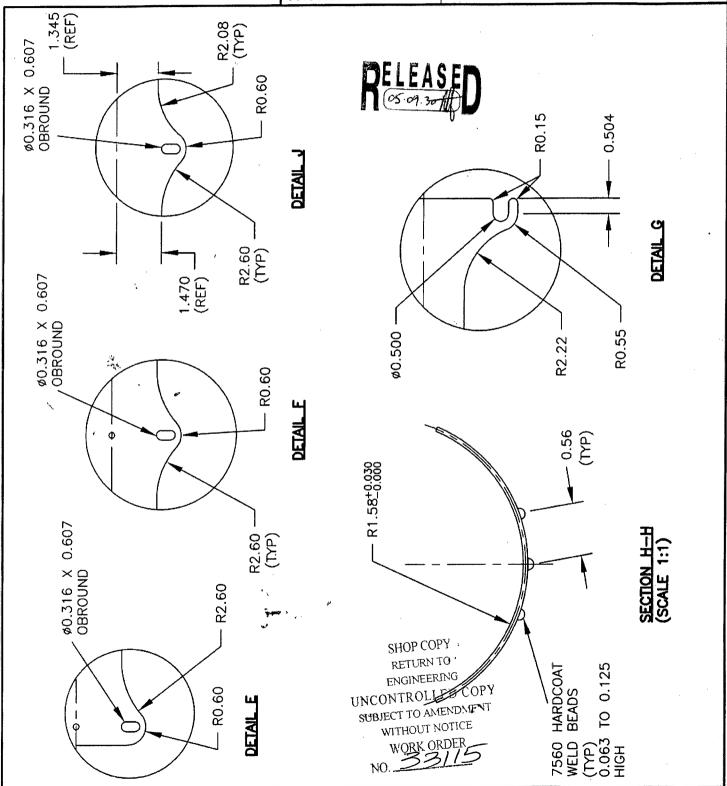
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PURPOSE

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DESIGN PH	DRAWN BY		ROSPACE LTD , ONTARIO, CANADA
CHECKED	APPROVED AN	DRAWING NO.	REV. B
di	#	D3319	SHEET 5 OF 5
DATE	· · · · · · · · · · · · · · · · · · ·	TITLE	SCALE
05.06.06		WEARPLATE	1:3



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DART AEROSPACE LTD	Work Order:	33115
Description: WEAR PLATE	Part Number:	D33197
Inspection Dwg: D3319 Rev:		Page 1 of 1

,	FIRST A	ARTICLE IN	SPECTIO	ON CHE	CKLIST		
	X	First Artic	le	Prote	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method Inspecti		mments
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17.75 6.163	4/- ,030	75.61	V		M.T		
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Δ	New Issue					KJ/JLM	

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Rev	Date	Change	Revised by	Approved
Α		New Issue	KJ/JLM	